








Work Order ID 51970

Friday, September 11, 2009 8:30:27 AM





Page 1


Item ID: D3296-041 *BK* Accept  Setup Start 
Revision ID: A Stop 
Item Name: Door Assembly
Start Date: 9/11/2009 Start Qty: 9.00  Cust Item ID:
Required Date: 9/17/2009 Req'd Qty: 9.00  Customer:
Reference:

Approvals: Process Plan: *BK* Date: *09-9-11* Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3296	Rev A								


100  Small Fab 0.00
Small Fab Memo 0.00
Small Fab Fabricate & assemble as per Dwg D3296.
Transfer drill using DT8470 & DT9521

09/09/15 

110  QC5- Inspect part completeness to step on W/O 0.00
QC Memo 0.00
Quality Control

=> 8/26/15

 *φ*

120  Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00
Powdercoat Memo 0.00
Powder Coating START TIME: *9:00AM* OVEN TEMPERATURE:
9:30AM FINISH TIME: *3:20PM*

=> 09/09/17

X9 *φ*

Work Order ID 51970

Friday, September 11, 2009 8:30:27 AM

Page 2

Item ID: D3296-041

Accept

Revision ID: A

Item Name: Door Assembly

Start Date: 9/11/2009 Start Qty: 9.00

Required Date: 9/17/2009 Req'd Qty: 9.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

09-09-17

(9)

140



Small Fab

Small Fab

Small Fab

Memo

Assemble as per Dwg D3296

0.00

0.00

E/309/09/23 (9)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2) 8/21/23

(45)

Work Order ID 51970

Friday, September 11, 2009 8:30:27 AM



Page 3

Item ID: D3296-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Door Assembly

Start Date: 9/11/2009 Start Qty: 9.00



Cust Item ID:

Required Date: 9/17/2009 Req'd Qty: 9.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging Packaging	Identify as per dwg & Stock Location <u>218</u> Memo	0.00 0.00				<u>9/9/23</u>		<u>(9x)</u>	<u>SP</u>
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

09/09/23 HJ
MF 09-09-23

Picklist Print

Friday, September 11, 2009 8:30:33 AM

Page 1
4

Work Order ID: 51970

Parent Item: D3296-041RevA

Parent Item Name: Door Assembly





Comments:

Start Date: 9/11/2009

Required Date: 9/17/2009

Start Qty: 9.00

Required Qty: 9.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3161-7RevA2		Manufactured	No			100	Each	0.0000	9.0000			
						B51601					EP 09/09/14	
Hinge 14.0"												
D3161-9RevA2		Manufactured	No			100	Each	4.0000	9.0000			
											EP 09/09/14	
Hinge 17.0"												

Warehouse

Loc Qty

Loc Code

Location

B51632

(5X)

Main Warehouse

ST73

4

51174

4

4

D3296-1RevA

Manufactured No

100

Each

17.0000

9.0000



Door Panel

EP 09/09/14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

50765

17

9

D3296-3RevA

Manufactured No

100

Each

9.0000

9.0000



Door Panel

EP 09/09/14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

9

50766

9

9

Picklist Print

Page 2

Friday, September 11, 2009 8:30:33 AM

Work Order ID: 51970



Parent Item: D3296-041RevA



Parent Item Name: Door Assembly

Start Date: 9/11/2009

Required Date: 9/17/2009

Comments:

Start Qty: 9.00

Required Qty: 9.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20470AD4-6 Purchased No



Rivet, Universal Head

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2572

109371

64

110915

993

112492

1515

AN960JD6 Purchased No



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1510

104537

1114

6085

396

D2137 Manufactured No



Decal - No Step

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

108012

85

45851

10

ES 09/09/14

ES 09/09/14

ES 09/09/14

352033 (40)

Friday, September 11, 2009 8:30:34 AM

Shop Packet Print

Page 2

Picklist Print

Page 3

Friday, September 11, 2009 8:30:34 AM

Work Order ID: 51970



Parent Item: D3296-041RevA



Parent Item Name: Door Assembly

Start Date: 9/11/2009

Required Date: 9/17/2009

Comments:

Start Qty: 9.00

Required Qty: 9.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2419RevA		Manufactured	No			140	Each	8.0000	9.0000			
Handle												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8

51173

8

D2462RevA1		Manufactured	No			140	f	791.0004	2.9997			
Seal												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST404

791.0004

48530

791.0004

D2728-1RevB		Manufactured	No			140	Each	0.0000	0.0000			
Dart Logo label												

2.9997

Picklist Print

Page 4

Friday, September 11, 2009 8:30:34 AM

Work Order ID: 51970



Parent Item: D3296-041RevA



Parent Item Name: Door Assembly



Start Date: 9/11/2009

Required Date: 9/17/2009

Comments:

Start Qty: 9.00

Required Qty: 9.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20470AD4-4		Purchased	No			140	Each	4,932.000	225.0000			
												
Rivet, Universal Head												

Ep 509/09/14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4932

111359

88

112314

4844

225

SHOP COPY
RETURN TO
ENGINEERING

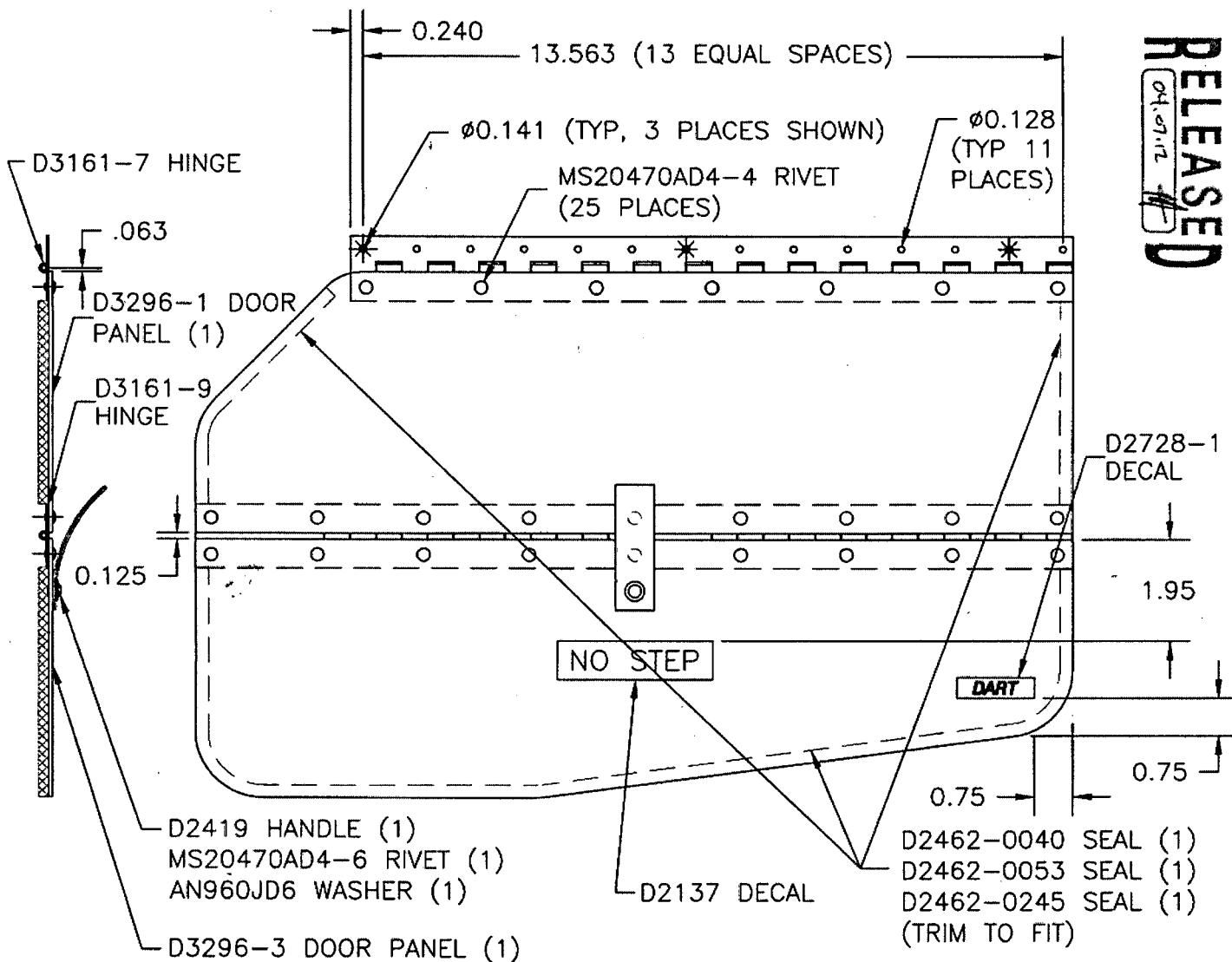
DART



UNCONTROLLED
SUBJECT WITH
WORK ORDER
NO 51970

DESIGN	IP	DRAWN BY	IP	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	IP	APPROVED	IP	DRAWING NO. D3296
DATE	04.06.28	TITLE	DOOR ASSEMBLY	REV. A 1 OF 2
A	04.06.28	NEW ISSUE		SCALE 1:3

RELEASED
04.07.12



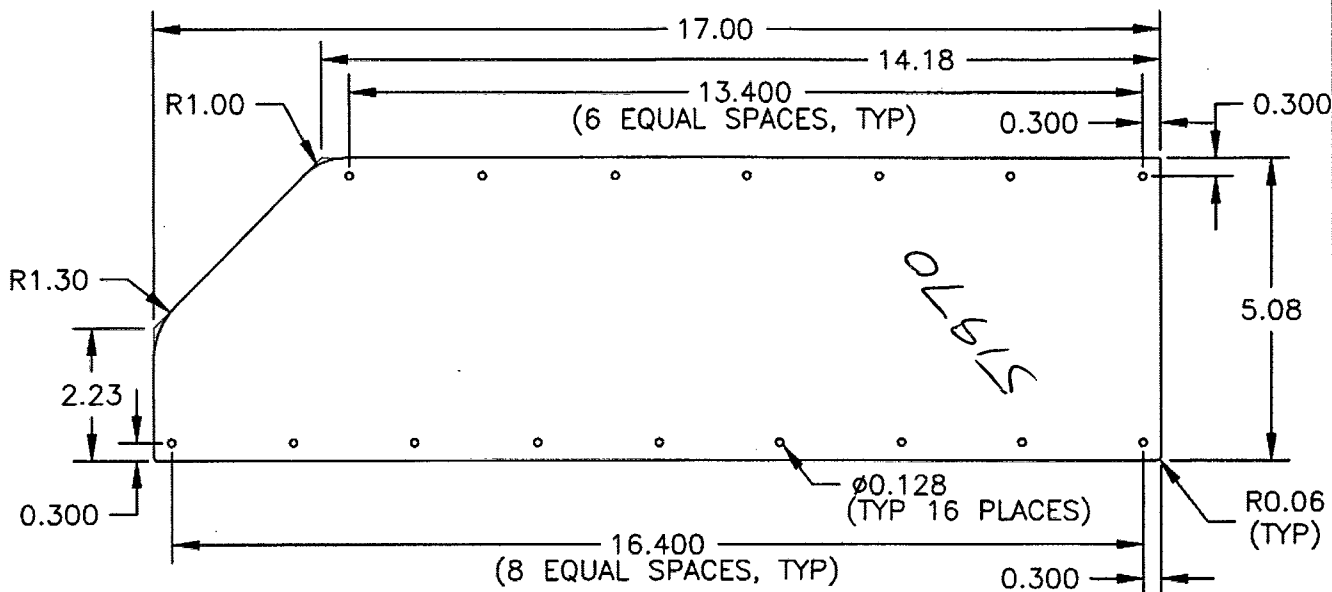
D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

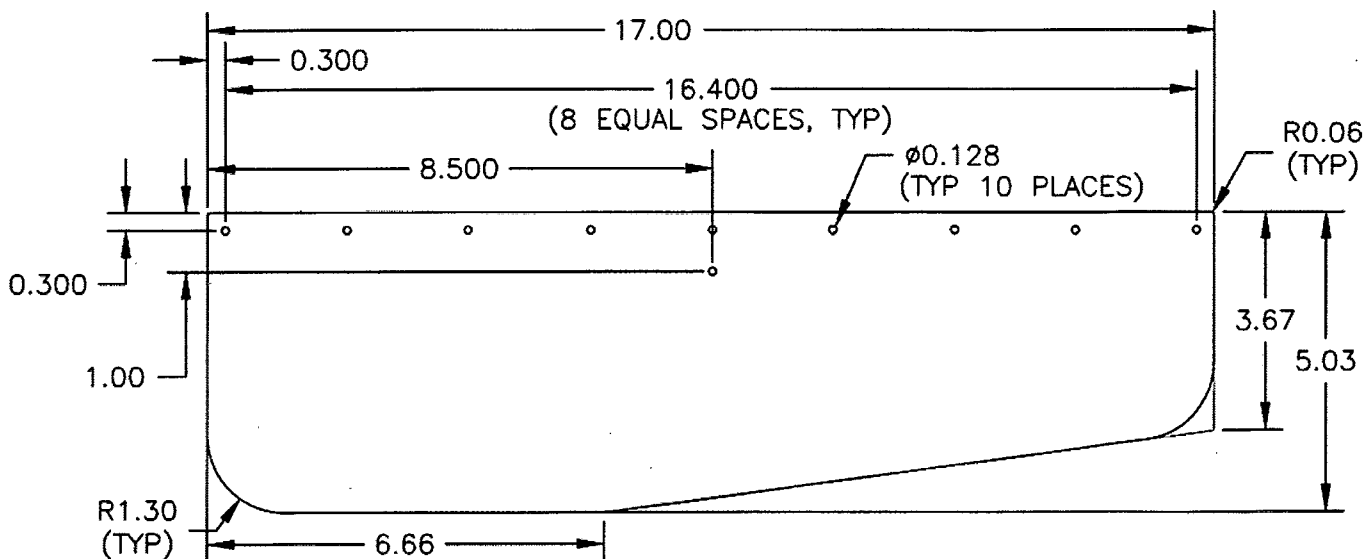
51970



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.